

Work Order ID 130337

March-06-15 8:07:27 AM

Ship March 16

130337

Page 1

Item ID: D350-567-145

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Window Close Out (AS350 B3e)

Stop *NS2*

Start Date: 3/06/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/13/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	F								
100	Document Control	0.00	DAS	27					
100	DOCUMENT CONTROL		9-89						
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

ML5 1503-11

(1x)

DAS
46
9-89

APR 16 2015

DAS
27
9-89

MAR 11 2015

DAS
6
9-89

(1x)

DAS
46
9-89

APR 16 2015

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Item ID: D350-567-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 3/06/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/13/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					(1x)	DAS 46	APR 16 2015	
Packaging	Memo	0.00					0.00		
Packaging	Identify and pack for shipping as per PPP D350-567-145 Location: <u>FG033</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLS 150417
MLS 150417

Picklist Print

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Work Order ID: 130337

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 3/06/15

Required Date: 3/13/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CB200 *CB200* Acrylic Adhesive, 3.5G	DAS 46 9-89	Purchased	No				Each	27.0000		1		DAS 27 9-89 MAR 11 2015	DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA2		27							
				129452		11							
				130685		16							
D4730-020-030 *D4730-020-030* Velcro Strip 2.0W/ X 3.0L	DAS 46 9-89	Manufactured	No				Each	0.0000		1		DAS 27 9-89 MAR 11 2015	DAS 6 9-89
D4971-041 *D4971-041* T/R Bellcrank Cover Assembly	DAS 46 9-89	Manufactured	No				Each	0.0000		1		DAS 27 9-89 MAR 11 2015	DAS 6 9-89
D5076-041 *D5076-041* Fwd Bracket Assembly	DAS 46 9-89	Manufactured	No				Each	0.0000		1		DAS 27 9-89 MAR 11 2015	DAS 6 9-89
D3802-1 *D3802-1* Windows Seal (\$ Per Foot)	DAS 46 9-89	Manufactured	No				f	186.0000		2		DAS 27 9-89 MAR 11 2015	DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST421		186							
				116673		6							
				122222		180							

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

1 X 24"

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 3/06/15

Required Date: 3/13/15

Start Qty: 1.00

Required Qty: 1.00

D4435-9 Manufactured No

Each

4.0000

2

DAS

DAS

D4435-9

DAS

**

27

6

Bracket

46

MAR 11 2015

9-89

Location

Loc Qty

Loc Code

ST107

4

128923

4

2

DAS

D4436-041

Manufactured No

Each

3.0000

1

DAS

D4436-041

DAS

**

27

DAS

Aft Bracket Assembly

46

MAR 11 2015

9-89

Location

Loc Qty

Loc Code

ST623

3

127849

3

1

DAS

D4441-1

Manufactured No

f

616.3750

2

DAS

D4441-1

DAS

**

27

Rubber Seal

46

MAR 11 2015

DAS

9-89

Location

Loc Qty

Loc Code

ST407

383.875

120932

383.875

2

1x24"

DAS

38

9-89

ST422

232.5

120932

232.5

2

(D4441-1-240) CUT (1) AT 24.00" PER KIT

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 3/06/15

Required Date: 3/13/15

Start Qty: 1.00

Required Qty: 1.00

AN3-3A

Purchased

No

Each

675.0000

5

AN3-3A

Bolt

DAS
46
9-29

**

MAR 11 2015

Location

Loc Qty

Loc Code

ST338a

458

113121

4

m116924

4

m131305

150

m131624

300

ST350

217

m129591

217

Each

208.0000

2

**

DAS
27
9-29

MAR 11 2015

AN525-10R6

Purchased

No

AN525-10R6

Screw

DAS
46
9-29

Location

Loc Qty

Loc Code

ST273A

100

M129390

100

ST325A

100

M131420

100

ST329

8

M130325

8

Each

57.0000

2

**

DAS
27
9-29

MAR 11 2015

AN525-832R7

Purchased

No

AN525-832R7

Screw

DAS
46
9-29

Location

Loc Qty

Loc Code

GA

56

m129909

56

ST329

1

m127363

1

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Shop Packet Print

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 3/06/15

Required Date: 3/13/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L06

Purchased

No

Each

408.0000

7

MS21042L06

DAS
46
9-89

Nut

**

DAS
27
9-89

MAR 11 2015

Location

Loc Qty

Loc Code

ST260a

300

m131317

300

ST304

50

m131294

50

ST305

58

m129499

9

m130325

49

Each

2,334.000

2

MS21042L08

Purchased

No

MS21042L08

DAS
46
9-89

Nut

**

DAS
27
9-89

MAR 11 2015

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

1000

m131697

1000

ST304

1233

123900

16

m128401

156

m130325

61

m131317

500

m131624

500

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 3/06/15

Required Date: 3/13/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased
DAS
46
9-89

No

Each

2,300.000

5

DAS
27
9-89

MAR 11 2015

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

884

M131317

884

ST305

996

116549

18

M131264

239

M131624

739

MS21059L3

Purchased

No

Each

260.0000

2

DAS
27
9-89

MAR 11 2015

MS21059L3

Nut Plate

**

Location

Loc Qty

Loc Code

CA

16

M129682

16

GA

34

113749

10

M130823

24

ST303

210

M131616

210

MS35206-229

Purchased

No

Each

48.0000

7

DAS
27
9-89

MAR 11 2015

MS35206-229

Screw

**

Location

Loc Qty

Loc Code

ST277

48

M131078

48

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Picklist Print

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Parent Item: D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

130337

D350-567-145

Start Date: 3/06/15

Required Date: 3/13/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

4,231.000

10

NAS1149F0332P

Washer

DAS
46
9-89

**

DAS
27
9-89

DAS
6
9-89

MAR 11 2015

Location

Loc Qty

Loc Code

GA

222

122063

222

ST260a

2586

m128401

6

m131026

80

m131697

2500

st268

1423

m130325

1423

Each

86.0000

14

NAS1149FN616P

Purchased

No

NAS1149FN616P

WASHER

DAS
46
9-89

**

DAS
27
9-89

DAS
6
9-89

MAR 11 2015

Location

Loc Qty

Loc Code

st268

86

M131026

86

Each

808.0000

2

NAS1149FN816P

Purchased

No

NAS1149FN816P

WASHER

DAS
46
9-89

**

DAS
27
9-89

DAS
6
9-89

MAR 11 2015

Location

Loc Qty

Loc Code

st268

808

117316

808

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Shop Packet Print

Page 6

REFERENCE ONLY

DAS
46

APR 16 2015

9-39

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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